User: Linda	day, 05/11/2007 10:19:04 AM						
	a Lacelle	Proc	ess Sheet				
Customer Job Number Estimate Number P.O. Number This Issue Prsht Rev. First Issue Previous Run Written By Checked & Approv	: 35512 /ed By : Est B 04.12.06 N	Services SMALL /MED FAB Made in-house KJ/JLM	Part Number Drawing Number Project Number Drawing Revision Material Due Date	: GASKET : D32563 : D3256 REVC : N/A : C : : 12/11/2007	Qty:	5 Um :	Eac
Additional Product		2/water jet 07-11-05 DD	verified by:EC				
Additional Product	•						
Job Number:							
Seq. #:	Machine Or Operation:		Description :				
1.0	D3245	Gasket		il			
		8 .568					
Comm	ent: Qty.: 1.0710 sf(s)/Unit	Total: 5.3550 sf(s)		<u></u>			
	GASKET						
	Batch: 3115%	1B07-11-6					
2.0	WATER JET	FLOW V	VATER JET				
Comm	ent: FLOW WATER JET						
	1-Cut as per Dwg D3256		<i>t</i> .		lox.	12	
	Dwg Rev: Prog Rev:	B 07-11-	6			(0)	
	1 10g 1001						
	2-Deburr if necessary			· · · · · · · · · · · · · · · · · · ·			
3.0	QC2	INSPEC	T PARTS AS THEY COME	OFF MACHINE	 		
		B 07-11-6					-
Comm	ent: INSPECT PARTS AS THEY			1 168118 18181	(1877 BIBY 1881		
4.0	QC8		O CHECK				
					too	lop	
	ent: SECOND CHECK		S B/41	06 (X	8)		
	PACKAGING 1	PACKAG	GING RESOURCE #1				
5.0							
5.0	ent: PACKAGING RESOURCE	#1					
5.0							

Date: ~

Monday, 05/11/2007 10:19:04 AM

User:

Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GASKET

Job Number: 35512

Part Number: D32563

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC21



FINAL INSPECTION/W/O RELEASE

D'11 01

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U Stillist

User: First Issue Comment

Friday, 02/11/2007 2:21:35 PM

Linda Lacelle

Process Sheet

: CU-DAR001 Dart Helicopters Services Customer

Job Number : 35512 **Estimate Number** : 11159

P.O. Number

This Issue

: 02/11/2007 S.O. No. :

: NC Prsht Rev.

: 11 : 34949 **Previous Run**

Written By

Checked & Approved By

: Est B

Type

Made in-house KJ/JLM

: SMALL /MED FAB

Est Rev ECN 1052 07-10-31 DD verified by:

Additional Product

Job Number:



Seq. #:

1.0

2.0

Machine Or Operation:

D3245



Comment: Qty.:

1.0000 sf(s)/Unit

Total:

5.0000 sf(s)

Batch:

Gasket

GASKET

Comment: SMALL & MEDIUM FAB RESOURCE 1

Fabricate as per Dwg D3256

Material: Durabla Black Gasket 0.035" thick

(D3245)

QC6

DIMENS ONAL CHECK

PACKAGING RESQURCE #1



Comment: DIMENSIONAL CHECK

4.0

3.0

PACKAGING 1



Comment: PACKAGING RESOURCE #1

Identify and Stock Location:

5.0

QC21

FINAL INSPECTION/W/O RELEAS

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



: GASKET **Drawing Name**

Part Number

Description:

SMALL & MEDIUM FAB RESOURCE 1

: D32563 : D3256 REVC : N/A

Drawing Number Project Number

Drawing Revision

Material **Due Date**

: 09/11/2007

: C

Qty:

5 Um:

Each

Dart Aerospace Ltd

W/O:		WORK ORDE	R CHANGES				
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
			•				
Part No		PAR #: Fault Category:	NCR: Yes	No DQ	A:	Date: _	
			QA:	N/C Close	d:	_ Date: _	
NCD.		WORK ORDER NON-C	ONFORMANCE (NC	R)			

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
		Description of NC	Description of NC Corrective Action Section B			Verification	A	A
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspecto
						,		
							· .	

NOTE: Date & initial all entries

- 1.50 → R0.13 (4 PLACES) 0.45 1.30 B (TYP) R0.50 (12 PLACES) 6.10 4.15 (REF) 0.65 0.65 -**D3256-3 ACCESS PANEL**



NOTES:
1) MATERIAL: DURABLA BLACK GASKET 0.035 THICK PER MIL-A-7021C OR MIL-A-17472B (CLASS 1 & 2) OR MIL-G-12803A (GRADE P-1161A)
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: N/A
7) WEIGHT: 0.08 lbs

DESIGN	74	DART AEROSPACE LTD				
DRAWN	JA	HAWKESBURY, ONTARK				
CHECKED	PH	DRAWING NO.	REV. C			
MFG. APPR.	177	□ D3256	SHEET 2 OF 2			
APPROVED	143	TITLE	SCALE			
DE APPR.	#	ACCESS PANEL	1:2			
DATE OT C	10 28	COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRINATE AND COMPONITION AND IS SUPPLIED BY THE EXPRESS CONDITION THAT IT IS				

8

5

Dart Aerospace Ltd

W/O:			WOF	RK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANG	GE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
			i see			·			
						÷			
Part No	•	PAR	t#: Fault Catego	ory:	ICR: Yes	No DQ	A:	Date:	

QA: N/C Closed: ____ Date: ___

NCR:	CR: WORK ORDER NON-CONFORMANCE (NCR)							
		Description of NC		Corrective Action Section B		Verification	A	A
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector
		v						
•								
						1		

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 35512	
Description: GASKET		
BOSON SKISH. GASKET	Part Number: D3256-3	<u>. </u>
Inspection Dwg: D3256-3 Rev: C	Page 1 of	<u> </u>

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

						
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
₹4.00	4030	24.00	*	·		
6.10	t/- 130	6,69	¥			
11.25	+1030	11.25	*			
10.55	1/030	10.55	¥			
1.60	1/020	1.58	×	_		
1.50	+/030	1.48	*			
4.15	⁺ / ₋ .030	4.15	M			
	1/2 .030	1.39	×			
	1/2 .030	.63	*			
	1/030	164	4			
.45	1/- 1030	,نوح	*			•
			-			

	7		
Measured by: R	Audited by:	Prototype Approval:	4)
Date: 67-11-6	Date: Alu	Date:	19
		 	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	Applotes

